

FF. Rucker

Work Order ID 73823



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Friday, September 16, 2011 11:30:05 AM

Item ID:	D2884	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle Spacer					
Start Date:	9/16/2011	Start Qty:	200.00		Cust Item ID:	
Required Date:	10/14/2011	Req'd Qty:	200.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2884	Rev B								

100	0.00	
	FLOW WATER JET	
Waterjet	Memo	0.00
FLOW CNC Waterjet	1-Cut as per Dwg D2884 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-	
6061 . 08U	Tumble ,Deburr if necessary	

B11-9-26

258

110	0.00	
	QC2- Inspect parts off machine FAI/FAIB	
QC	Memo	0.00
Quality Control		

B1-9-26

120	0.00	
	QC8- Inspect parts - second check	
QC	Memo	0.00
Quality Control		

8 w/09/26

count

1208

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73823

Friday, September 16, 2011 11:30:05 AM



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Item ID: D2884

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/16/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				208		11-9-26	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				208 count	6	11-9-26	
150 Packaging Packaging	Identify as per dwg & Stock Location <u>25</u> Memo	0.00 0.00				count		11-9-26	208

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Work Order ID 73823

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Friday, September 16, 2011 11:30:05 AM

Item ID: D2884

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/16/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 *[Signature]*
MF 11-09-26

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 11:30:02 AM

Page 1

Work Order ID: 73823



Parent Item: D2884

Parent Item Name: Saddle Spacer

Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP A□99.10.12□New Issue□EC□
IPP Rev:B Now 6061-T6 06-06-23 JLM
IPP Rev:C Now on Waterjet 06-08-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	116.3000	0.0631	13.28421			

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

116.3

116268

9.5

117285

106.8

119009

1811-9-26

119009

200

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NOTE: Date & initial all entries

73823

☒ **First Article** ☐ **Prototype**

Measured by: B	Audited by: 8.	Prototype Approval: N/A
Date: 11-9-26	Date: 11/09/26	Date: N/A

by <i>JA</i>	Approved <i>EE</i>
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

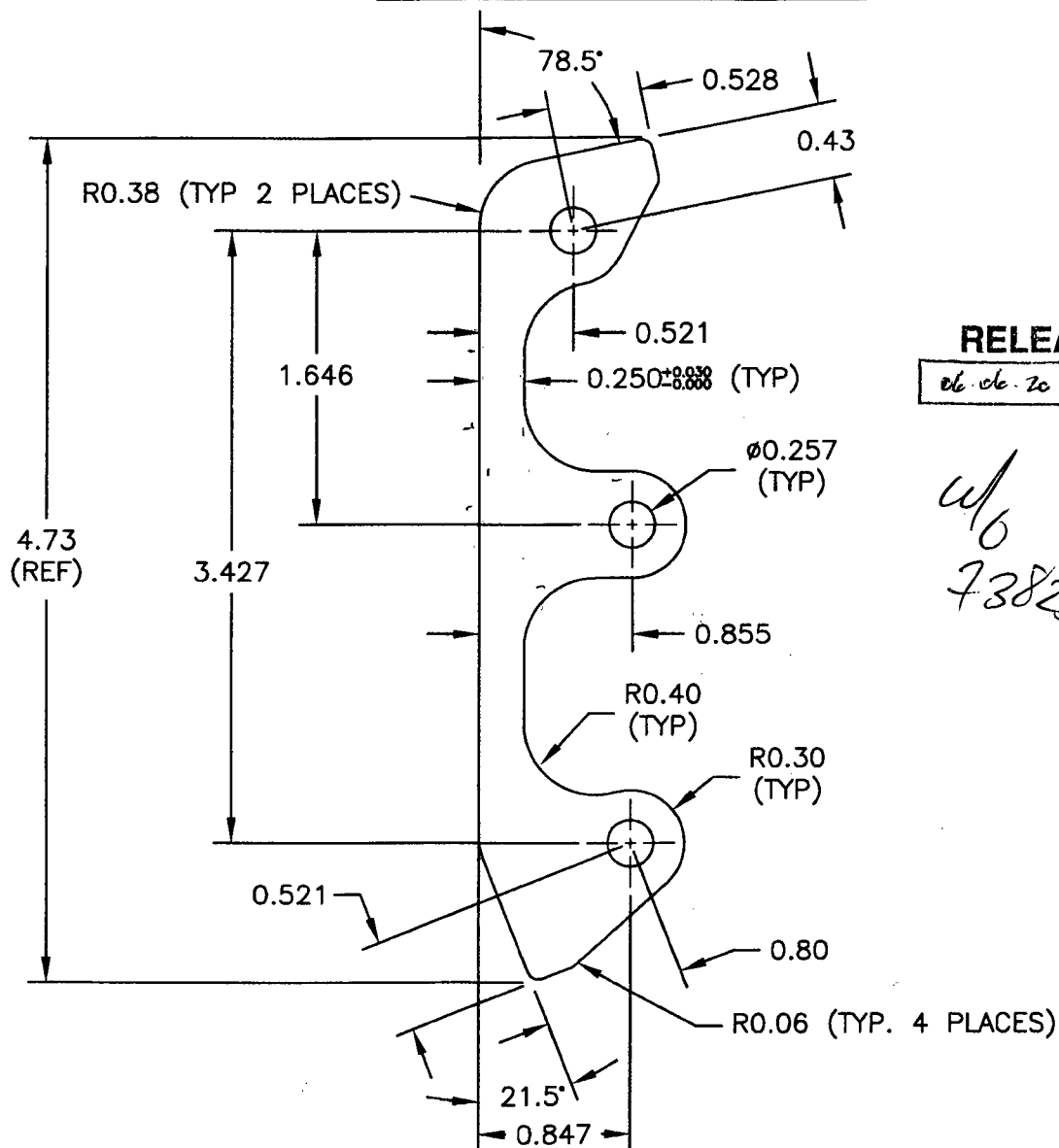
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2884	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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